

Work Order ID 114239

May-23-14 10:12:12 AM

114239

Page 1

Item ID: D4796-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 3/04/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 3/04/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4796	B								

105 0.00

105

Purchasing

Purchasing

Memo

ISSUE PO

Cut Blank as per D4796-1_blank File

0.00

CL 14/05/26 8

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Packaging

Memo

0.00

8x 14-6-10
SR

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Quality Control

Memo

0.00

CL 14/07/19

8 x

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Page 2

Item ID: D4796-1

Revision ID:

Item Name: Bearpaw

Start Date: 3/04/14

Start Qty: 8.00

Required Date: 3/04/14

Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

1-Inspect material for defects or damage prior to machining
2-Machine as per FolioFB178 and Dwg

FOLIO REV: 44
DWG REV: B

3-Deburr

and 14/07/19

8

0

140

140

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

and 14/07/19

8

0

150

150

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8

0

DAS

44

9-89

14/07/21

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Page 3

MLS 1407-22

Picklist Print

May-23-14 10:12:11 AM

Page 1

Work Order ID: 114239

114239

Parent Item: D4796-1

D4796-1

Parent Item Name: Bearpaw

Start Date: 3/04/14

Required Date: 3/04/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 13-03-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	400.0000		45			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

CL 14/05/28

Location

Loc Qty

Loc Code

MAT018

400

m128267

47

m128668

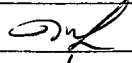
353

m129213

DART AEROSPACE LTD		Work Order: 114239
Description: Bearpaw		Part Number: D4796-1
Inspection Dwg: D4796	Rev: B	Page 1 of 1

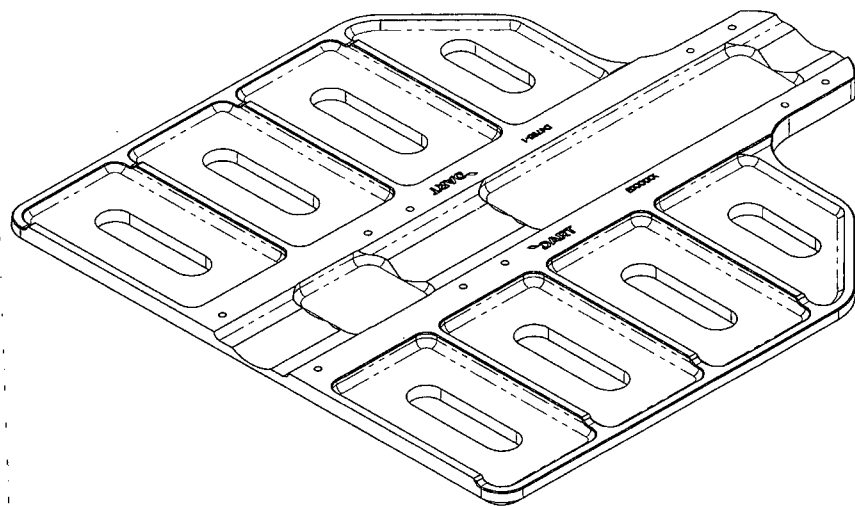
FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	.95	±.030	.953	—	Vern	ML-06
B	.74	±.030	.745	—	"	
C	R.25	±.030	R.250	—	R-G	
D	.46	±.030	.466	—	Vern	ML-06
E	.30 X 45°	±.030 X ±1/2	.385 X 45°	—	"	
F	21.46	±.030	21.460	—	M-type	ML-08
G	1.28	±.030	1.290	—	Vern	ML-06
H	.38	±.030	.380	—	"	
I	3.63	±.030	3.630	—	"	
J	7.15	±.030	7.150	—	"	
K	12.47	±.030	12.470	—	M-type	ML-08
L	1.38	±.030	1.380	—	Vern	ML-06
M	5.63	±.030	5.626	—	"	
N	27.00	±.030	27.000	—	M-type	ML-08
O	2.000	±.005	2.000	—	Vern	ML-06
P	.91	±.030	.900	—	"	
Q	4.540	±.005	4.540	—	"	
R	24.00	±.030	24.000	—	M-type	ML-08
S	.24	±.030	.240	—	Vern	ML-06
T	3.60	±.030	3.600	—		
U	.50	±.030	.501	—		
V	6.40	±.030	6.400	—		
W	3.52	±.030	3.510	—		
X	Ø.261	±.005 ±.001	Ø.261	—		
Y	Ø.650	±.010	Ø.658	DAS		

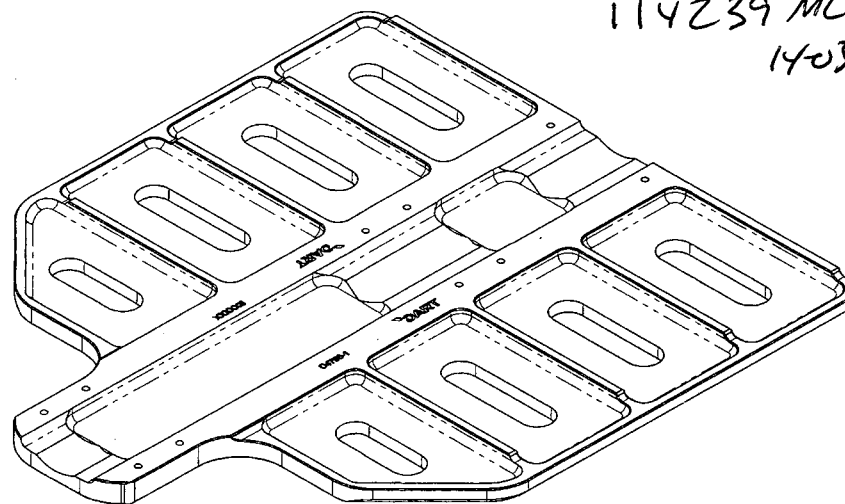
Measured by: 	Audited by: 44 9-89	Preliminary Approval:
Date: 14/02/19	Date: 14/03/21	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.15



D4796-1 BEARPAW

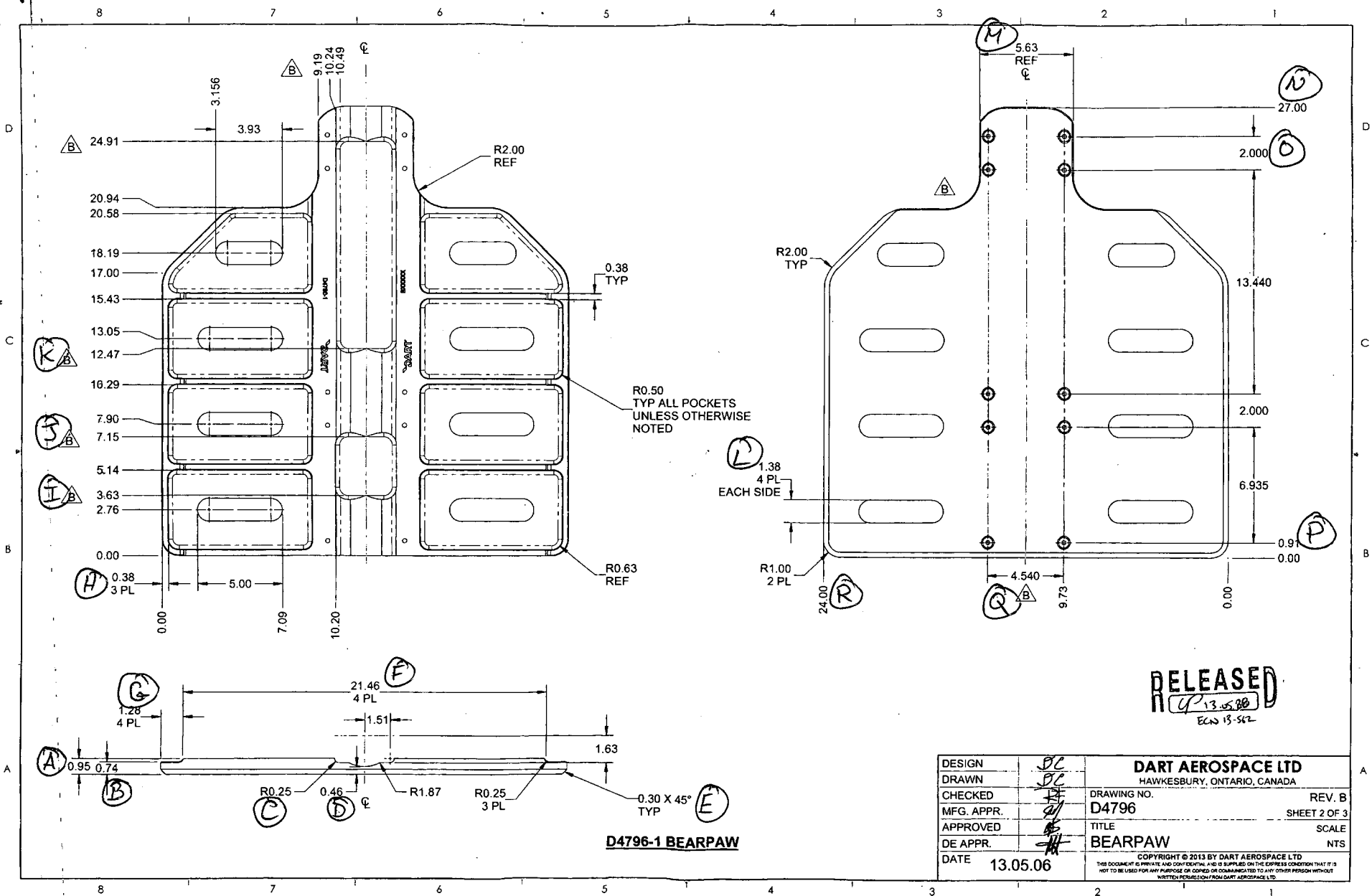


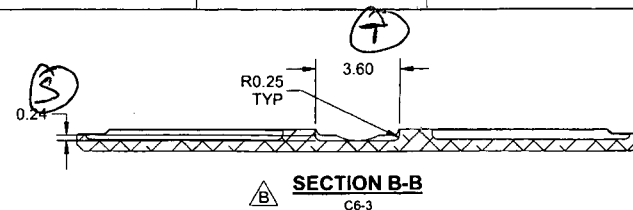
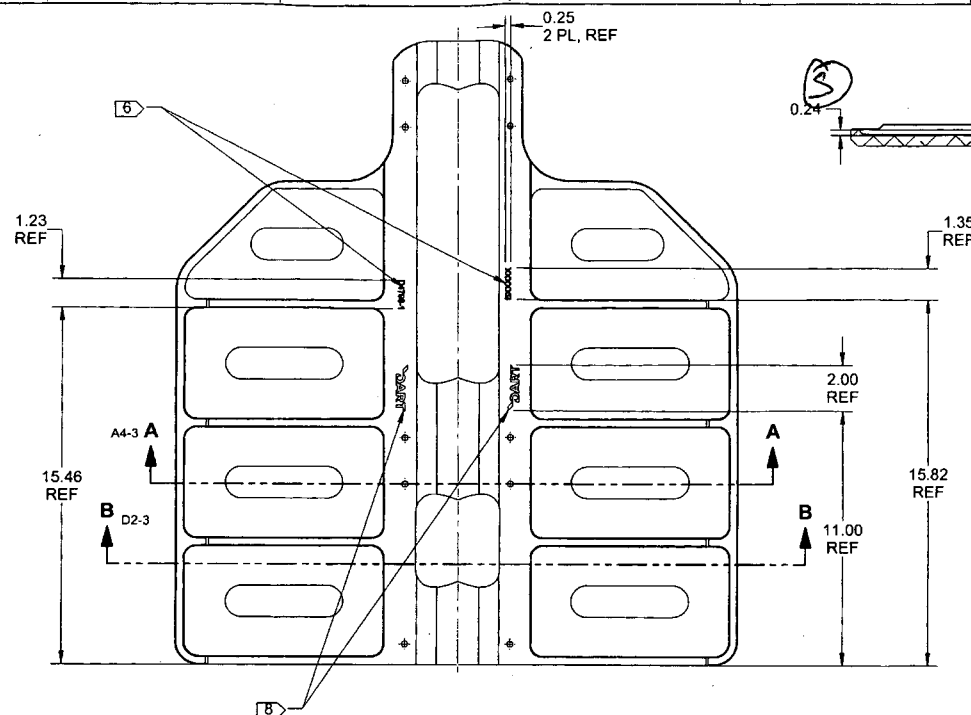
RELEASED
13.05.06
ECN 13-362

NOTES:

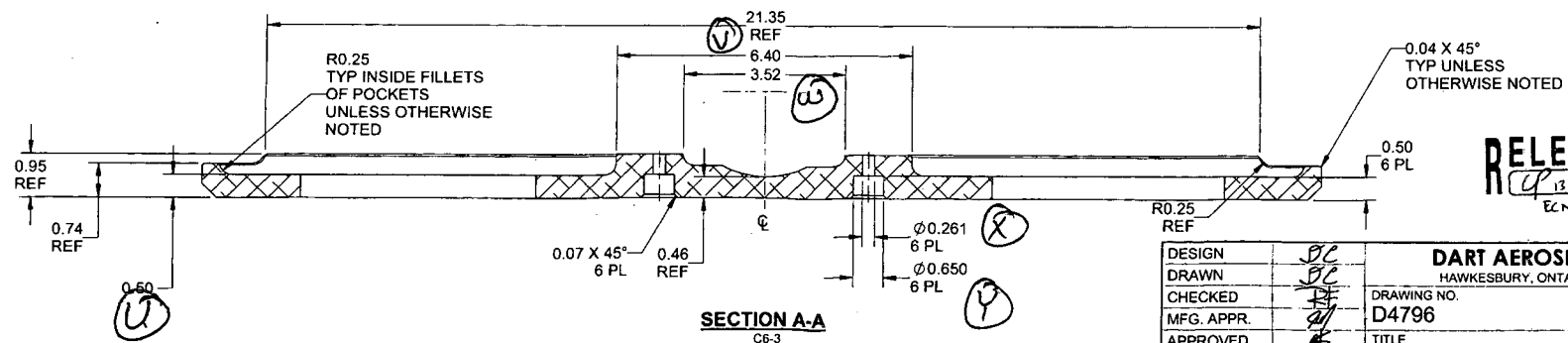
- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMWB10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 7) WEIGHT: 9.59 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD

B	MODIFIED SHAPE, MOVE HOLES FROM 4.938 TO 4.54 APART, ZN B2-2, ADD POCKETS FOR SKIDTUBE, ZN B6-2, C6-2, ADD SECTION B-B, ZN D2-3	DC	13.05.06
A	NEW ISSUE	DC	13.03.19
REV.	DESCRIPTION	BY	DATE
DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4796	SHEET 1 OF 3
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	BEARPAW	NTS
DATE	13.05.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	





D4796-1 BEARPAW
(SUPPLEMENTAL VIEW)



SECTION A-A
C6-3

RELEASED
13.05.06
ECN 13-562

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO. D4796	REV. B
MFG. APPR.	BC		SHEET 3 OF 3
APPROVED	BC	TITLE BEARPAW	SCALE
DE APPR.	BC		NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24350

Purchase Order Date 5/26/2014

PO Print Date 5/26/2014

Page Number 4 of 4

Order From :

VC-TPI001

Ship To : DART AEROSPACE LTD

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-633-0484

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Day & Ross collect

Ship Acct:

10 114239

D4796-1 BEARPAW

6/13/2014

8.00

\$44.64

\$357.1

Yes

6/13/2014

CUT BLANK AS PER FILE

Line Total:

\$357.1

11 114237

D4930-1 BEARPAW

6/13/2014

8.00

\$22.54

\$180.3

Yes

6/13/2014

CUT BLANK AS PER FILE

Line Total:

\$180.3

12 118920

D4930-3 BEARPAW

6/13/2014

10.00

\$25.29

\$252.8

Yes

6/13/2014

CUT BLANK AS PER FILE

Line Total:

\$252.8

PO Total:

\$3,252.3

SP14-6-10

W C L

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr:

1

Change Date: 5/26/2014